

Date: Tuesday, 10/3/2006 3:48:05 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
 Job Number : 28864
 Estimate Number : 10937
 P.O. Number : N/A Part Number : D29392
 This Issue : 10/3/2006 S.O. No. : N/A Drawing Number : D2939 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
 Previous Run : 27119 Material : N/A
 Due Date : 10/30/2006 Qty: 8 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est: B 09.06.26 New DWG rev (mpp 2069) EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6101001

7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length

Batch No: B25343X4

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

5-Deburr

SD/JL 06/10/13

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SD/JL 06/10/13

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SD/JL 06/10/13

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 06/10/14 x8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *RD* Date: 06/10/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/3/2006 3:48:05 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 28864

Part Number: D29392

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

YH

06/10/14 X 8

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M101575

YH

06/10/14 X 8

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

P 4/12/16

(8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57476*

P 4/12/16

(8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(8) 06/10/16

Job Completion



U 06/10/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 28864
Description: 206 Saddle, Inboard, Right side	Part Number: D2939-2
Inspection Dwg: D2939 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.122	.121	.122	.123		
B	0.100	0.140		.123	.122	.122	.123		
C	0.100	0.140		.123	.121	.123	.122		
D	0.210	0.230		.220	.221	.220	.222		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.000		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.578	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	.258	.258	.258	.258		
L	0.312	0.317	DT8686	.313	.313	.313	.313		
M	0.235	0.240		.237	.238	.237	.237		
N	0.100	0.140		.120	.122	.120	.121		
O	0.540	0.560		.550	.550	.549	.550		
P	0.490	0.510		.500	.500	.499	.498		
Q	3.715	3.725		3.720	3.720	3.719	3.720		
R	2.720	2.760		2.745	2.745	2.745	2.745		
S	0.240	0.270		.252	.252	.253	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.631	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.366	1.367		
W	0.316	0.321	DT8690	.318	.318	.318	.318		
X	1.250	1.270		1.261	1.262	1.259	1.260		
Y	1.565	1.585	DT8695 A/B						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L.
Date:	06/10/11

Audited by:	E
Date:	06/10/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#

DART AEROSPACE LTD	Work Order: 28864
Description: 206 Saddle, Inboard, Right side	Part Number: D2939-2
Inspection Dwg: D2939 Rev. B	Page 1 of 1

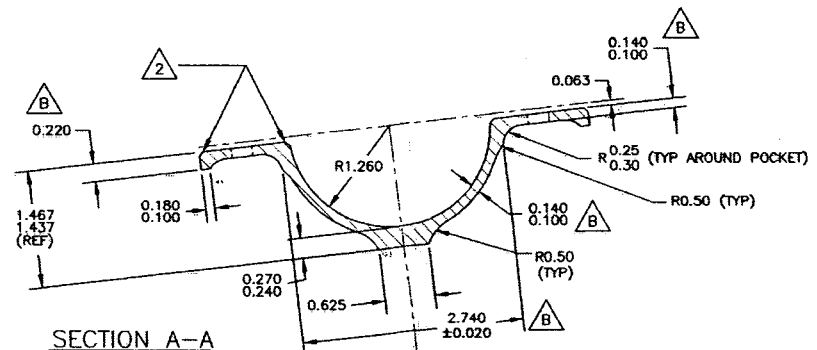
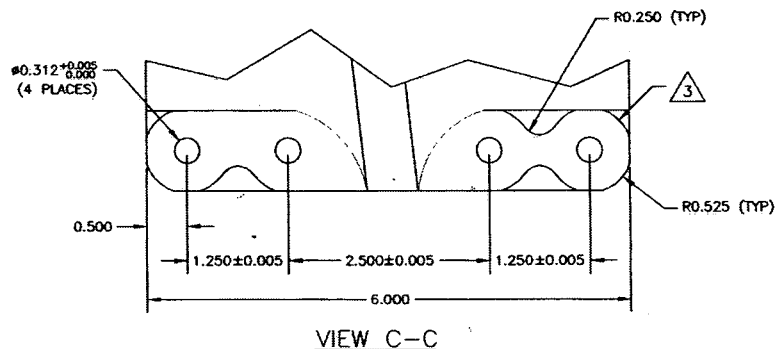
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.123	.123	.124	.123		
B	0.100	0.140		.113	.123	.124	.124		
C	0.100	0.140		.123	.123	.121	.121		
D	0.210	0.230		.222	.221	.221	.221		
E	1.245	1.255		1.256	1.258	1.258	1.258		
F	1.245	1.255		1.256	1.258	1.258	1.258		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8685	.258	.258	.258	.258		
L	0.312	0.317	DT8686	.314	.314	.314	.314		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		.121	.121	.120	.120		
O	0.540	0.560		.549	.549	.549	.549		
P	0.490	0.510		.499	.496	.500	.498		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.745	2.745	2.745	2.745		
S	0.240	0.270		.251	.251	.251	.251		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	.319	.319	.319	.319		
X	1.250	1.270		1.259	1.258	1.258	1.260		
Y	1.565	1.585	DT8695 A/B	/	/	/	/		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD
Date:	06.10.12

Audited by:	Er
Date:	06/10/14

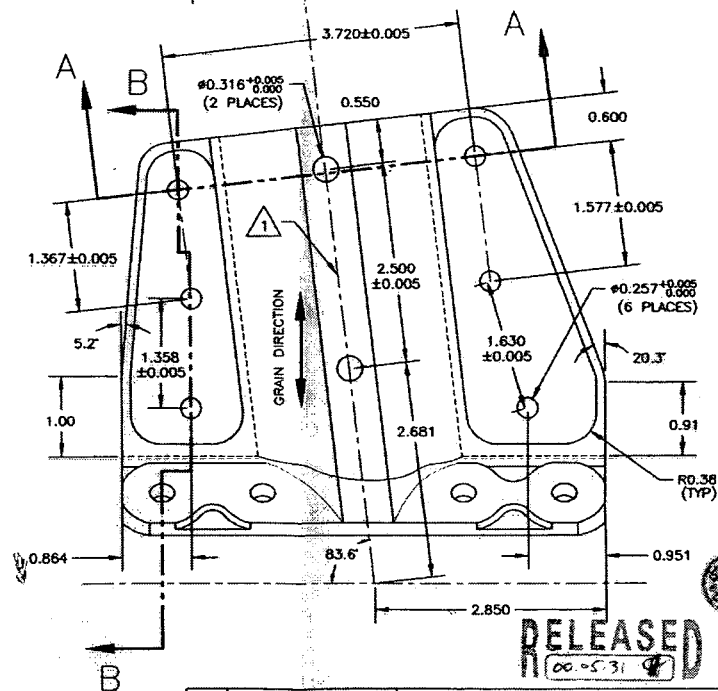
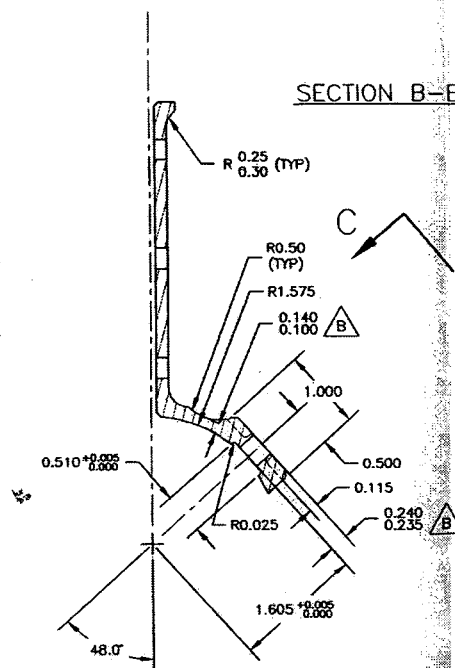
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#



D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
 DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)
- 3 CHAMFER 0.050" x 45°



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 28864

B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	RF	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2939
DATE	00.05.29	TITLE SADDLE INSIDE
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		REV. B SHEET 1 OF 1 SCALE 2:3